

Split

Date: Tuesday, 03/06/2008 7:32:57 AM  
\*User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 39661 - 1  
Estimate Number : 10930  
P.O. Number :  
This Issue : 03/06/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : MACHINED PARTS  
Previous Run : 39432  
Written By :  
Checked & Approved By :  
Comment : Est D 02.08.22 Make in Cobra KJ  
Est Rev:E 08-05-27 as per ECN1195P DD verified by:EC

Drawing Name : PLUG  
Part Number : D2057  
Drawing Number : D2057 PRELIM  
Project Number : N/A  
Drawing Revision : PRELIM  
Material :  
Due Date : 10/06/2008 Qty: 30 Um: Each

(5)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.1050 f(s)/Unit Total: 3.1500 f(s)  
6061-T6 Round Bar .750"  
Material: 6061-T6 (QQ-A-225/8) Ø0.75 Rod  
(M6061T6R0.750) Batch M103857 mmv= 08/06/04

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL  
Make as per Dwg D2057 and Folio FA260.  
Break all sharp edges 0.015 max. Do not drill Ø0.191

DJP/mm= 08/06/04

3.0 QC6 - QCC DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

DJP/mm= 08/06/04

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

SB 08/06/04

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-04

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_




QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

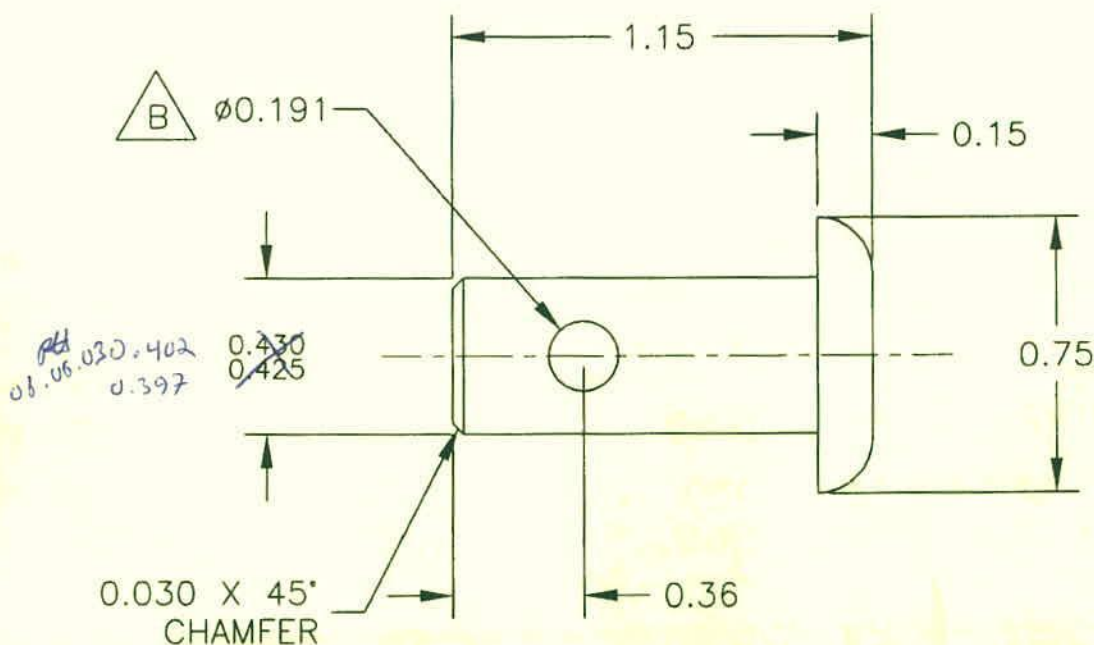
NOTE: Date & initial all entries





DESIGN JB		DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 	DRAWING NO. D2057	REV. B SHEET 1 OF 1
DATE 98.10.15			TITLE PLUG	SCALE 2:1
A	92.03.13		NEW ISSUE	
B	98.10.15		REDRAWN 0.191 DIA WAS 0.187 DIA (TSR A1100)	

RELEASED  
98.10.16 PS



~~UNDER REVIEW~~  
08.05.27 PH  
0.430/0.425 TO  
BECOME SMALLER Dk  
D2010-103/-104 IS  
CHANGING

MATERIAL: 6061-T6 ROD (QQ-A-225/8)  
FINISH: NONE  
BREAK ALL SHARP EDGES 0.015 MAX  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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